

Date: Thursday, 10/08/2006 10:02:17 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ASPIRATOR	
Job Number	: 28138		Part Number	: D2061	
Estimate Number	: 11968		Drawing Number	: D2061 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/08/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 05/09/2006 Qty: 25 Um: Each	
Previous Run	: N/A				
Written By					
Checked & Approved By					
Comment	: Est: B 01.12.17 Added step 3, 4 and Inspection Level 21. SM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  
		Comment: PURCHASING Issue P/O: 1809 Make per Dwg D2061 Possible Supplier: Sieg's Manufacturing Material release note required  <i>C206108110 (25)</i>
2.0	D2061P	Aspirator  
		Comment: Qty.: 1.0000 Each(s)/Unit Total.: 25.0000 Each(s) ASPIRATOR BODY  <i>6/9/01 (25)</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1  
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached  <i>6/9/01 (25)</i>
4.0	QC6	DIMENSIONAL CHECK  
		Comment: DIMENSIONAL CHECK  <i>6/9/01 25</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and clean to remove was residue  <i>FF 06.09.10 25</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/07/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:02:17 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 28138

Part Number: D2061

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/09/20

25

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C2A

SB 06/09/20

55

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/09/20

25

Job Completion



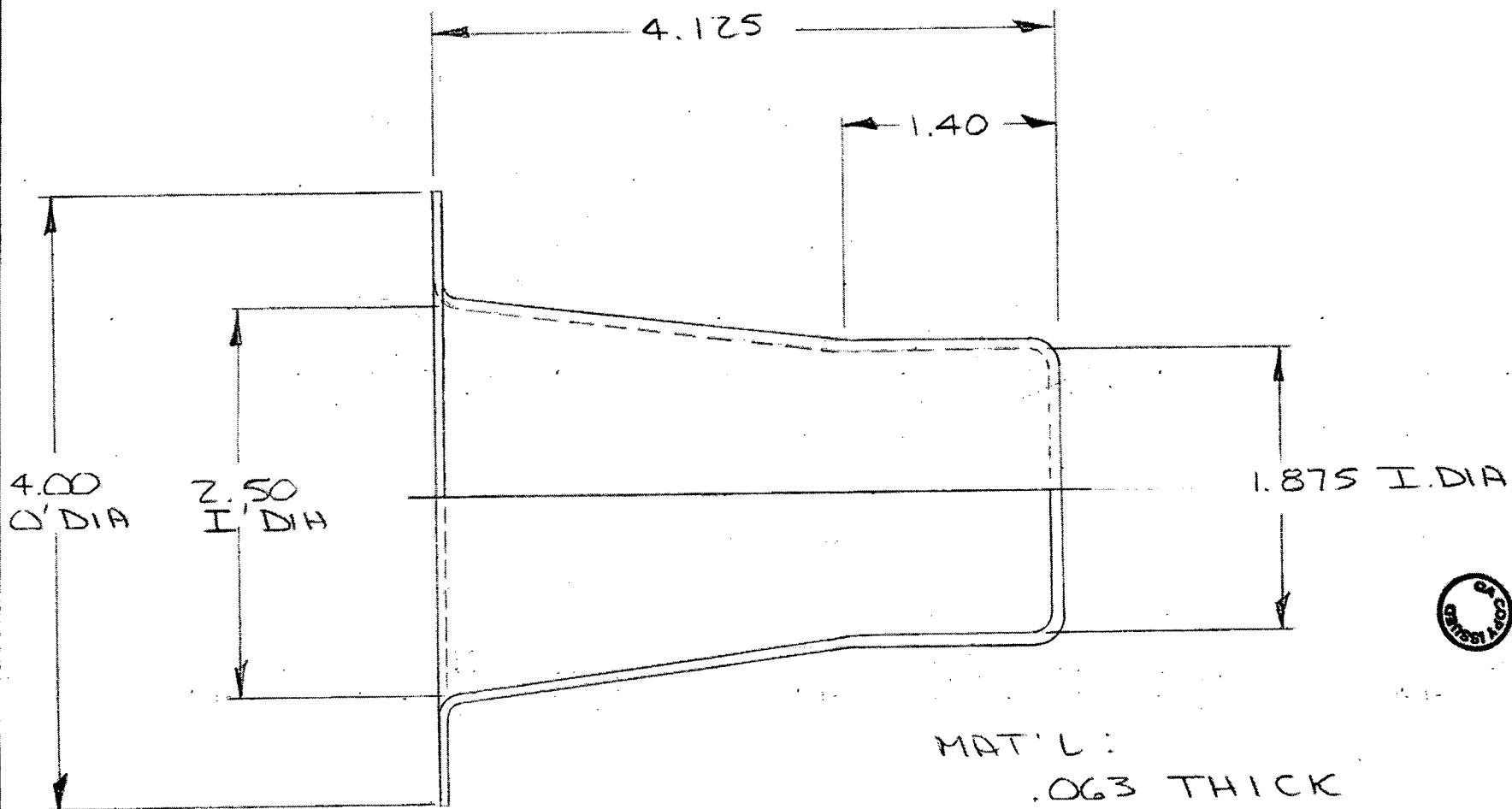
U 06/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



REVISION					
DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.				
APPROVED					
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED				
	GENERAL	LIMITS			
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS: .014 3. REMOVE SHARP EDGES: .015 MAX 4. THREADS PER IN. S: .2742 5. HOLES PER IN. 10387	1. TOLERANCES — .001 ± .010 2. ANGLES: .010 3. PARALLELISM: .0025 4. COLOC. TOLERANCE: .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES: .005				
REPORT ALL DISCREPANCIES — DO NOT SCALE					
RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM		
BASIC CODE D=DIMPLE C=CHAMFER S=SPOTWELD C-COUNTERSINK		DIA. DASH NO. RH/HEAD REAR SIDE FH/HEAD FWD SIDE	DESCRIPTION	MATERIAL	SPEC./VENDOR
D=SPOTWELD		LENGTH DASH NO. WNSPOTWELD	DART AERO ACCESSORIES INC. VANCOUVER, CANADA		
DRAWN: <i>Brayley</i> DATE: <i>10/24/92</i>		DESIGN: <i>Brayley</i> DATE: <i>10/24/92</i>			
STRESS		TITLE: ASPIRATOR BODY			REV. 1
CHECKED		CODE: YSD 2061			
CLIENT		SCALE: 1:1			

# sm

Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

## INSPECTION REPORT

DATE: Aug. 25/06

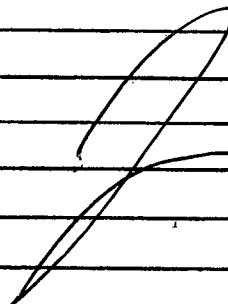
CUSTOMER: Dart Aerospace

INVOICE #: \_\_\_\_\_ SUPPLIER #: \_\_\_\_\_

DESCRIPTION OF INSPECTION: \_\_\_\_\_

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY
<u>Dab601P</u>	<u>25</u>	<u>.063 1100</u>	<u>N/A</u>	<u>✓</u>	<u>Kale</u>

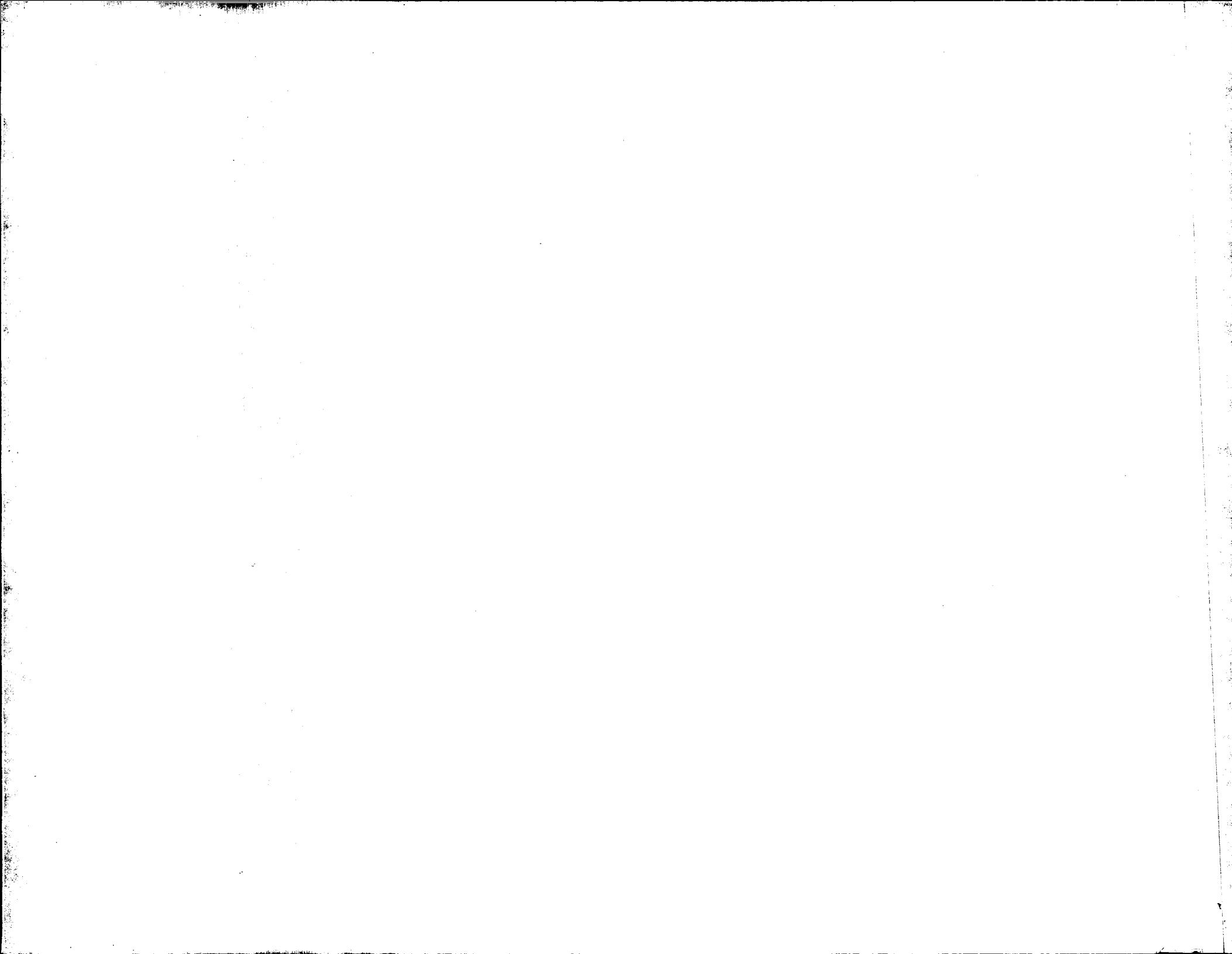
NOTES OF INSPECTION: Good.



NOTES OF REJECT: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_



**ALUMAX**  
MILL PRODUCTS, INC.  
1480 Mainline Pike, Lancaster PA 17601

**SOLD TO:**  
KEN-MAC METALS INC  
2 THYSSEN DRIVE  
DETROIT, MI 48210

## Certification of Test Results

TO BE ADVISED  
PA

SHIP TO  
PO 811326

ORDER NO	055535	PO NO	71993-D
ITEM NO	1	PART NO	
ALLOY	1100	TEMPER	O
GAUGE	06360	WIDTH	46.0000

FORM COIL  
LENGTH .0000

MILL FINISH  
NON ANODIZE QUALITY  
OUT: STANDARD MILL FINISH  
IN: STANDARD MILL FINISH  
NOT EMBOSSED

LOT: 004297 COIL: B01

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*EG25571	0.12	0.47	0.13	0.003	0.008	0.000	0.003	0.002	0.01

HEAD ULTIMATE STRENGTH 13.8 KSI  
TAIL ULTIMATE STRENGTH 13.9 KSI  
HEAD YIELD STRENGTH 5.5 KSI  
TAIL YIELD STRENGTH 5.2 KSI  
HEAD ELONGATION 30.5 %  
TAIL ELONGATION 30.5 %

\* AS REPORTED BY SUPPLIER  
MECHANICAL PROPERTIES ACCORDING TO ASTM B557

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
QQA 250/1P 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT  
\*\* END OF CERTIFICATION \*\*

Date 12-11-98  
Cust. 2482  
W/C # 4423484  
Qty. 555 Pcs.  
These test results are for material shipped  
on your PO# 2482  
From Copper & Brass Sales Inc.  
Quality Representative  
Customer Part #

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alumax sales order agreement.

Authorized By:

RON GANTZ